

### Abstract of the Disclosure

A laminated paperboard package is produced by initially printing graphics by high speed printing on a sheet of clay-coated publication paper. The printed paper is then continuously applied to a surface of cellulosic substrate and bonded to the substrate, preferably through use of starch as an adhesive, to provide a laminated product. The laminated product is then die cut to the desired shape, folded and glued into the configuration of a box or container. A layer of water absorbent, cellulosic fiber material can be bonded to the inner surface of the substrate to prevent moisture from the contained product from seeping outwardly through the substrate to the printed paper.